



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400224
Job Sheet 186034



Part No: RBT400224

Job Qty: 1 pcs

Part Name: Clevis Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 12/17/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400224 REV 3 IPP REV:A 17.07.17 NEW ISSUE DD VERF:JFS/IPP Rev B 18.11.06 was purchased now assembled in house DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Small Fab - 1	1 pcs	12/17/18	12/17/18	0.00	1.00	Small Fab - 1 - B4B	A.P. DEC 21 2018 GA sold
110	QC 5	1 pcs	12/17/18	12/17/18	0.00	0.00	QC 5 - 10	
120	Small Fab - 2 - B4B	1 pcs	12/17/18	12/17/18	0.00	1.00	Small Fab - 1 - B4B	
130	QC 5	1 pcs	12/17/18	12/17/18	0.00	0.00	QC 5 - 10	
140	Packaging 3-1 - Stock - B4B	1 pcs	12/17/18	12/17/18	0.00	0.00	Packaging 3 - 1 - B4B	
150	QC 21 - FG	1 pcs	12/17/18	12/17/18	0.00	0.00	QC 21 - FG - 16	

Part Op 100 - Assemble as per DWG. See note 4.
Descriptions: 120 - Load test as per DWG. See note 2.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3608T26	Plumber's Flat Link Chain	2 ft (2 ea)	100-Small Fab - 1	5126847
90177A228	Split Ring	1 Ea (1 ea)	100-Small Fab - 1	51138507-2
91654A076	Drive Screw #2 3/16" Long	3 Ea (3 ea)	100-Small Fab - 1	5015391
92384A013	Ball Lock Pin	1 Ea (1 ea)	100-Small Fab - 1	5065850
98381A542	Dowel Pin	2 Ea (2 ea)	100-Small Fab - 1	5089117
AN363-820	Nut	1 Ea (1 ea)	100-Small Fab - 1	5127329
AN960-816	Washer, Cage Bolt SEE PART NAS1149F0863P	2 pcs (2 ea)	100-Small Fab - 1	5058169
NAS1308-64	Bolt	1 Ea (1 ea)	100-Small Fab - 1	5127339
RBT400224-03	Clevis	1 pcs (1 ea)	100-Small Fab - 1	5138983
RBT400224-05	Bell	1 pcs (1 ea)	100-Small Fab - 1	5139002
RBT400224-07	Bolt Pin (Modified)	1 Ea (1 ea)	100-Small Fab - 1	5138992
3896T1	WIRE SLEEVE	3		5084066
CL-2-C	STEEL WIRE	1 FT		5093863

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3608T26	2	0	0
	90177A228	1	25	0
	91654A076	3	72	0
	92384A013	1	4	0
	98381A542	2	25	0
	AN363-820	1	0	0
	AN960-816	2	0	0
	NAS1308-64	1	0	0

RBT400224-03
RBT400224-05
RBT400224-07

1
1
1

0
0
0

0
0
0

Part Specifications

Specifications could not be found.

Plex 11/8/18 11:51 AM Dart.lajeunesse.marie



Container No: S139503



Part: RBT400224

Job No: 186034

Serial No/Batch: S139503

Revision: 3

Inspector:

Exp Date:

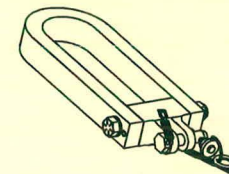
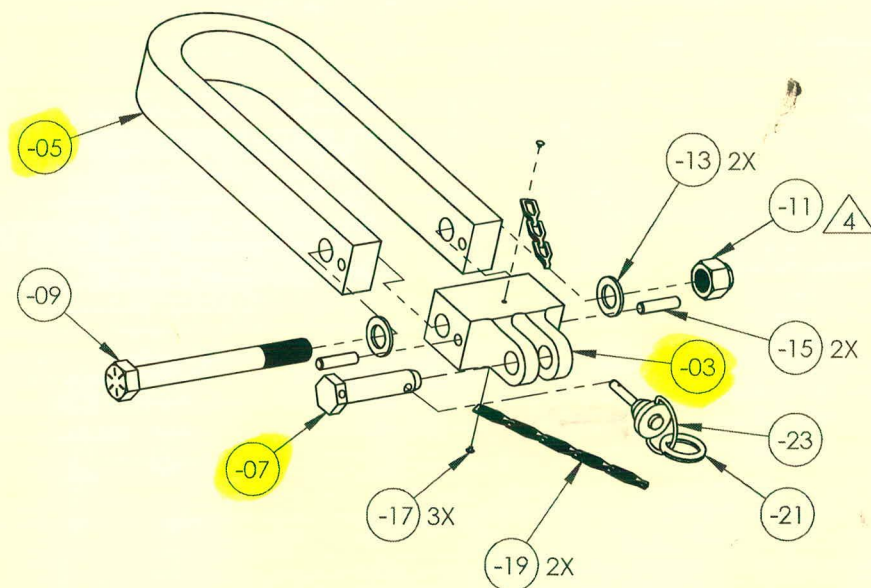
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/20/18

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-05 CORRECTED PROOF LOAD TESTING FROM 40000 LBS. TO 25000 lbs. AND CAPACITY TO 10000 lbs. PER INFORMATION FROM STAN.	7/20/2010	WP	RW
2		-07 CH'D FROM AN8-31A BACK TO NAS1308-38. -09 CH'D FROM AN8-46A TO NAS1308-64.	8/16/2010	WP	RW
3	15-0203	DELETED NOTE 3, ADDED NOTE 4.	8/13/2015	RJC	JAG



NOTE:

1. ORIGINAL T/N 204-011-178-001.
 2. PROOF LOAD TEST ASSEMBLY TO 25,000 lbs, WORK CAPACITY IS 10,000 lbs.
- 4 TORQUE -11 NUT TO 440-550 in. lbs.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-03	1	CLEVIS	4140/4142		2
			-05	1	BELL	4140/4142		3
			-07	1	BOLT PIN	STEEL	NAS1308-38 MODIFIED	4
		B/O	-09	1	BOLT	STEEL	NAS1308-64	
		B/O	-11	1	LOCK NUT	STEEL	AN363-820	
		B/O	-13	2	WASHER	STEEL	AN960-816	
		B/O	-15	2	DOWEL PIN	STEEL	Ø1/4 X 1 (MCMASTER-CARR #98381A542)	
		B/O	-17	3	#2 DRIVE SCREW	COATED STEEL	#.2 X 3/16 (MCMASTER-CARR #91654A076)	
		B/O	-19	2	PLUMBER'S FLAT LINK CHAIN	STEEL	2/0 SIZE X 4-7/8 (MCMASTER-CARR #3608T26)	
		B/O	-21	1	SPLIT RING	STEEL	Ø1 (MCMASTER-CARR #90177A228)	
		B/O	-23	1	BALL LOCK PIN	S.S.	Ø3/16 X 3/4 (MCMASTER-CARR #92384A013)	

DART AEROSPACE	
TITLE CLEVIS AND BELL	
DWG NO.	REV 3
RBT400224	
MAT'L	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 204
SCALE 1:1	DATE 6/16/2009
SHEET 1 OF 4	



Proof Load Capacity Test

Part Number

Revision

Serial Number

Date

RBT 400224

3

S139503

2018/DEC/20

Proof Load Capacity

25,000

LBS

Tested By:

ALAN PATRY

Technician

Approval: _____

Position: _____

QC 5 Small FAB / QA



Proof Load Capacity Test

Part Number

Revision

Serial Number

Date

BBT 400224

3

S139503

2018 / DEC / 20

Proof Load Capacity

25,000

LBS

Tested By:

ALAIN PATRY

Technician

Approval:

Position:

QC 5 Small FAB / QA

